

Work Order ID 58914

May 19, 2010 2:24:37 PM



Page 1

Item ID:	D3188-1M	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	SPACEPOD BODY LH					
Start Date:	5/19/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/18/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/5/19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev F								

100 0.00



Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:

11949

Description: D3188-1MBODY

Ship: QTY (8) D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

CZ 10/5/20 ①

110 0.00



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

P40/8/30 ①

[illegible]

May 19, 2010 2:24:37 PM

SECRET

00000000000000000000

[illegible][illegible]

Reference:

Abstract

[illegible]

**Insp.
Stamp**

8.10.09/13

[illegible]

0.00

Check for void spot and pins.

Identify as per dwg & Stock Location: Car 107 0.00

0.00

0.00

Packaging

0.00



0.00

Quality Control

10/09/14 JJ

10-9-13
①

Picklist Print

May 19, 2010 2:24:36 PM

Work Order ID: 58914

Parent Item: D3188-1M

Parent Item Name: SPACEPOD BODY LH

Start Date: 5/19/10

Required Date: 6/18/10

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
 IPP rev B revc dwg 07.01.11 ec
 IPP rev C revD dwg 07.03.07 ec
 IPP rev D rev E dwg 07.04.16 EC

Start Qty: 1.00

Required Qty: 1.00

D2213 Manufactured No 100 Each 243.0000 8



Insert



CL 10/5/20

Location

Loc Qty

Loc Code

ST008

243

30107

67

30809

176

8

D3188-1P

Purchased

No

110

Each

0.0000

1



Spacepod Body



B58914

BT 10-09-13

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

REFERENCE ONLY

RELEASED
2009-10-20

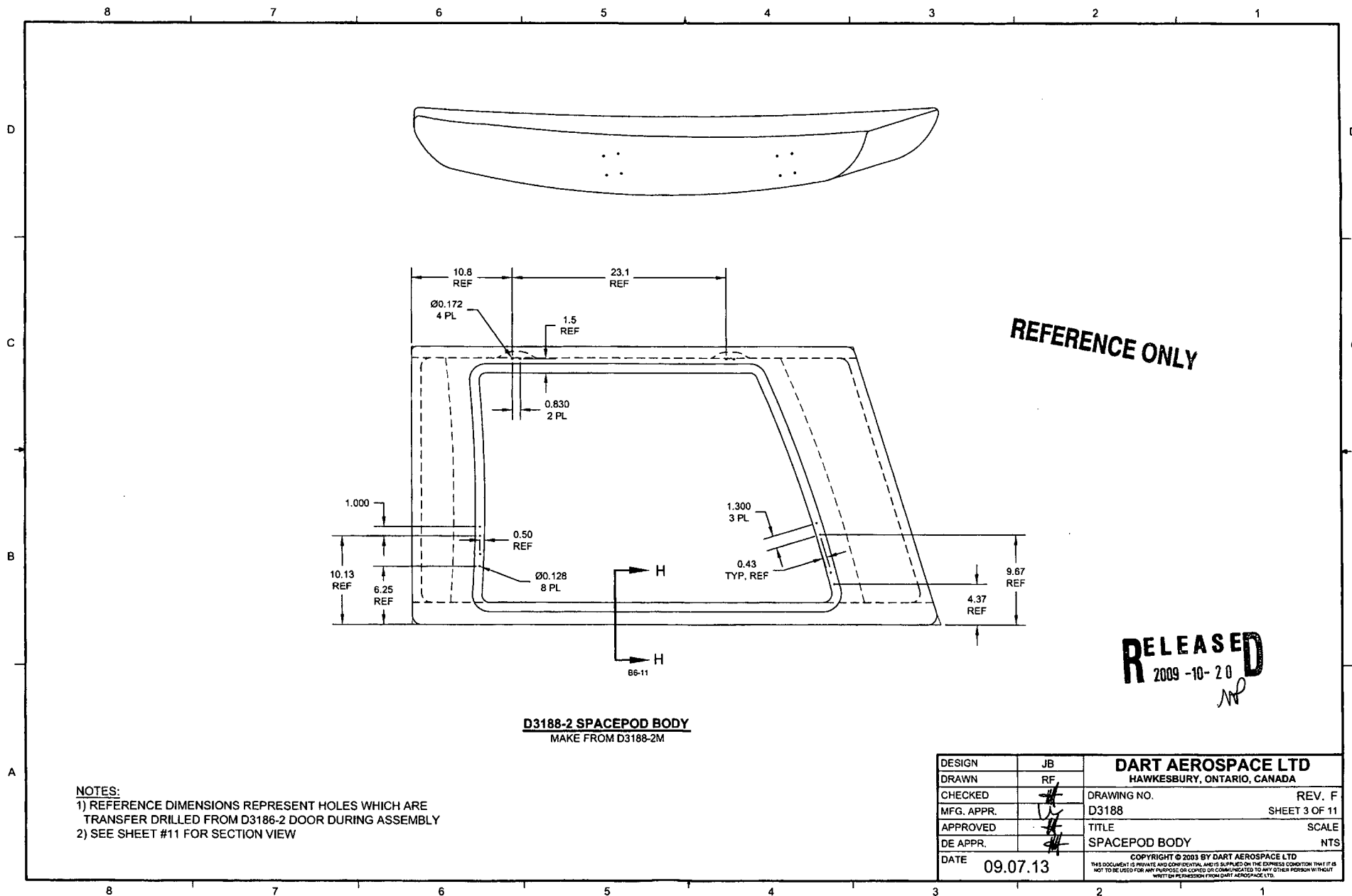
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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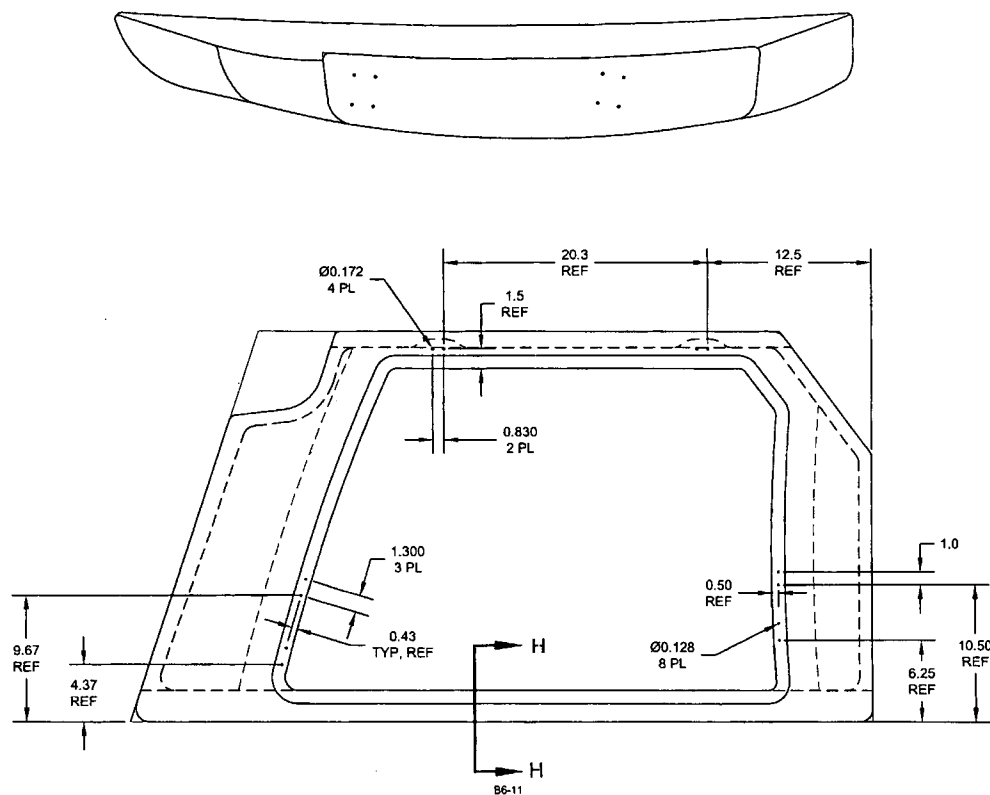


RELEASED
2009-10-20

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3188 TITLE SPACEPOD BODY COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. F
DRAWN	RF		SHEET 2 OF 11
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE 09.07.13			





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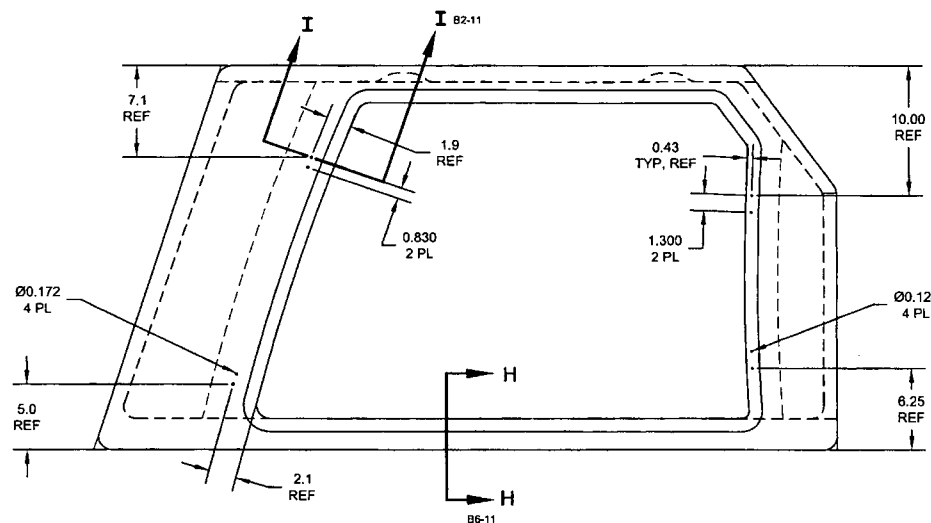
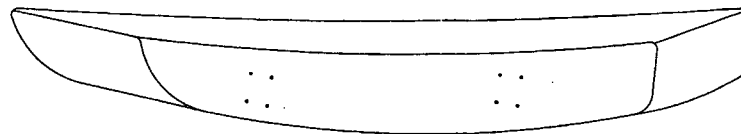
RELEASED
2009-10-20

D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
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REFERENCE ONLY

D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

RELEASED
2009-10-20

- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

D

D

C

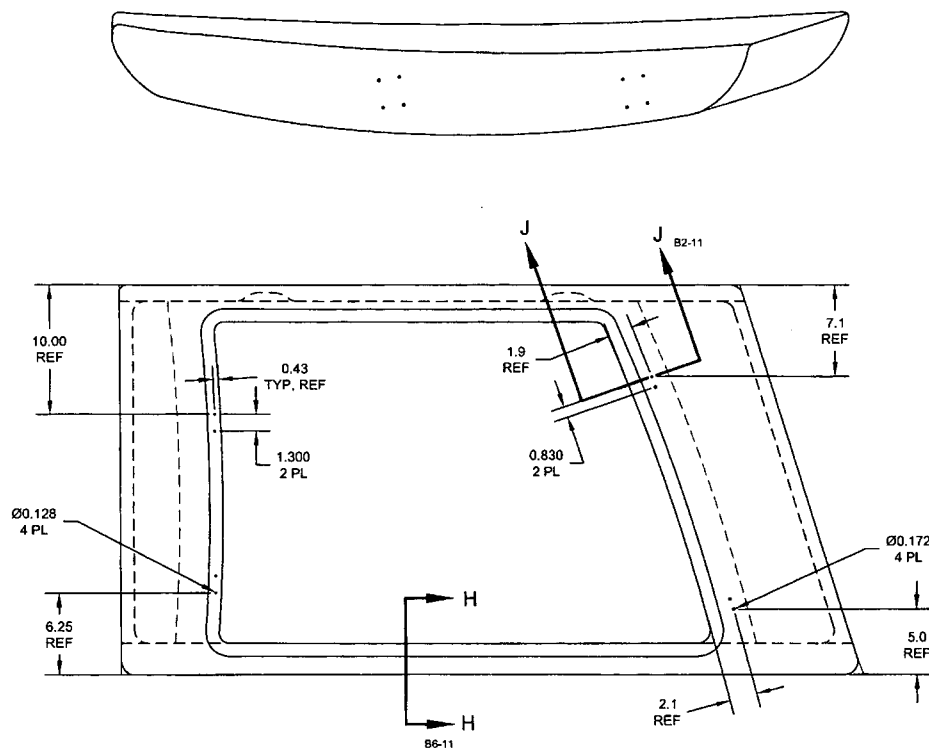
C

B

B

A

A



REFERENCE ONLY

D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

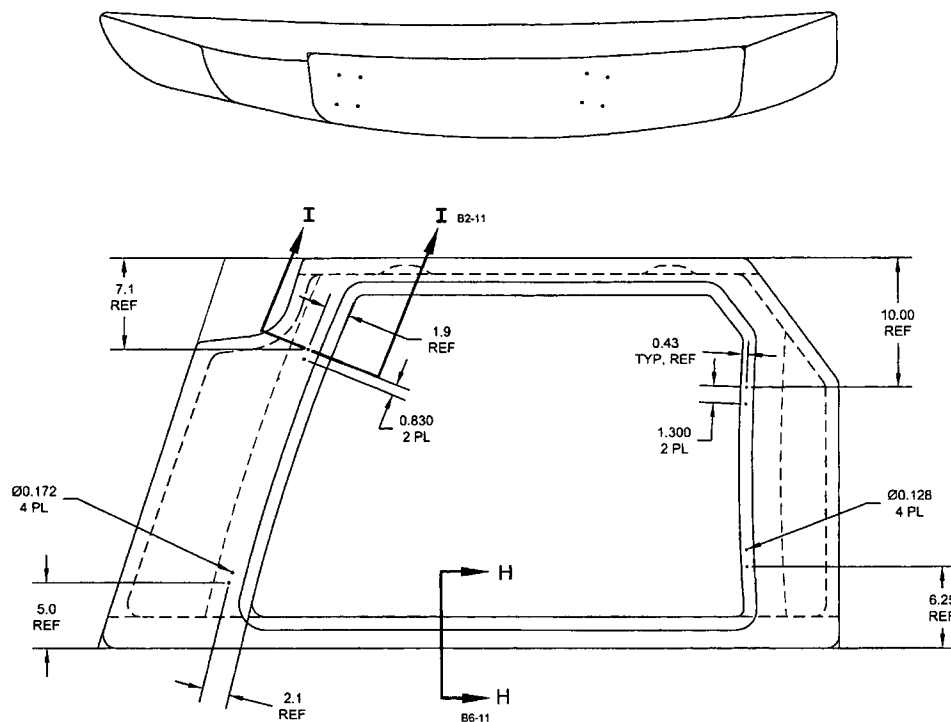
RELEASED
2009-10-20

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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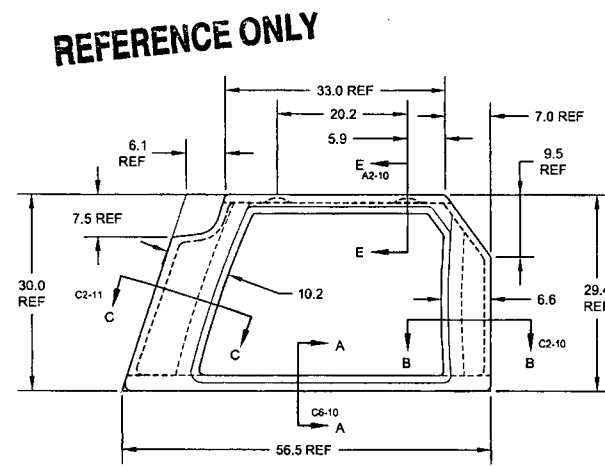
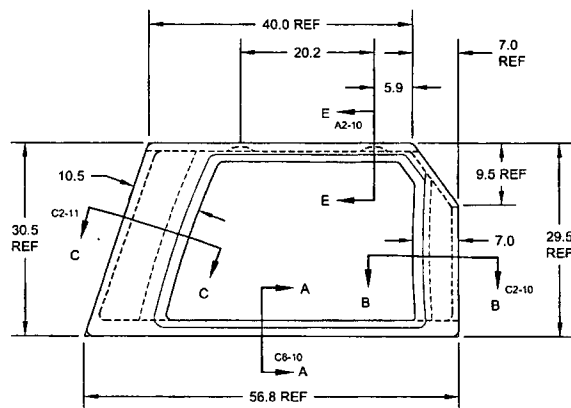
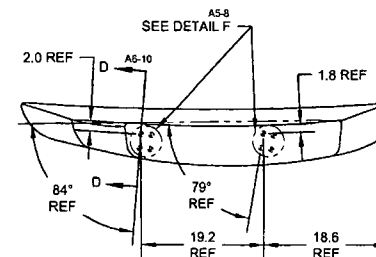
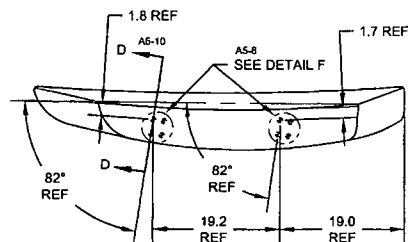
RELEASED
2009-10-20
MPT

D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

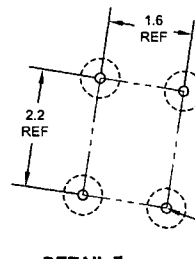
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D3186-1M SPACEPOD BODY

D3186-3M SPACEPOD BODY







DETAIL F

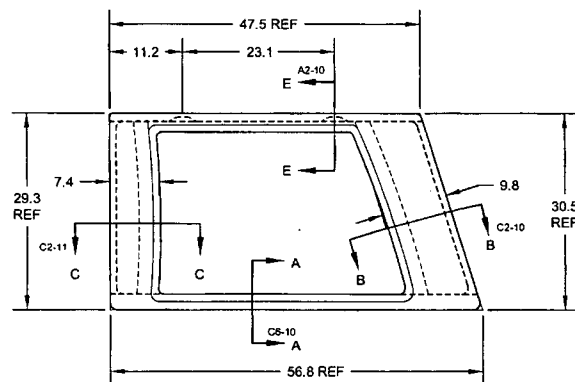
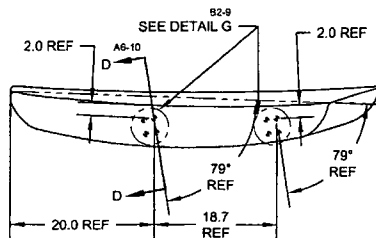
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A5-10

RELEASED
2009-10-20

D3186-1M/-3M NOTES:

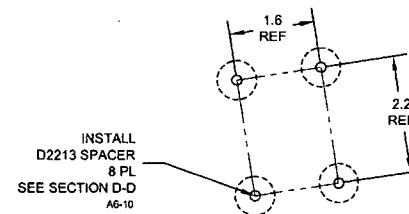
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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D3188-2M SPACEPOD BODY

REFERENCE ONLY



DETAIL G D6-8

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2009-10-20

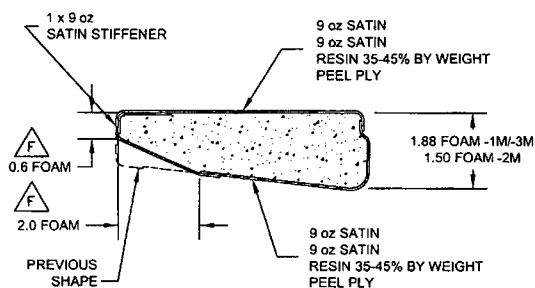
D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

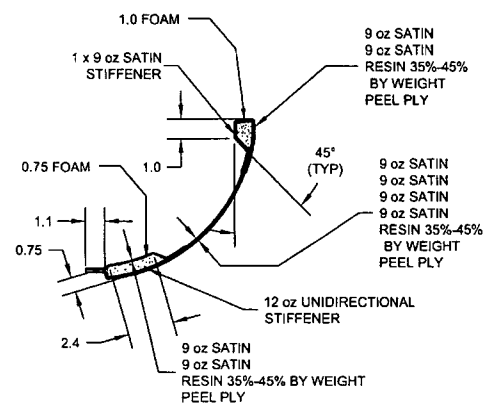
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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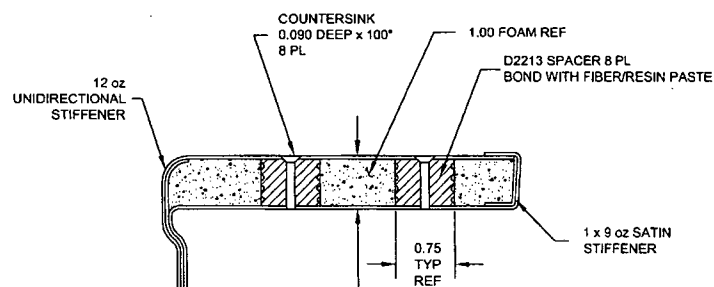
OUTBOARD



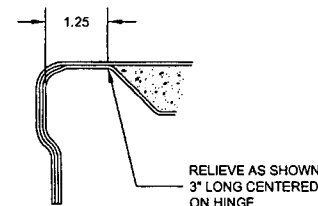
SECTION A-A
TYPICAL FLOOR SECTION
B7-8
B3-8
B6-9



SECTION B-B
SECTION C-C OPPOSITE
REFERENCE ONLY
B6-8
B3-8
B4-8
B2-8
B7-8
B5-9



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS
D3-8
D7-8
D6-8

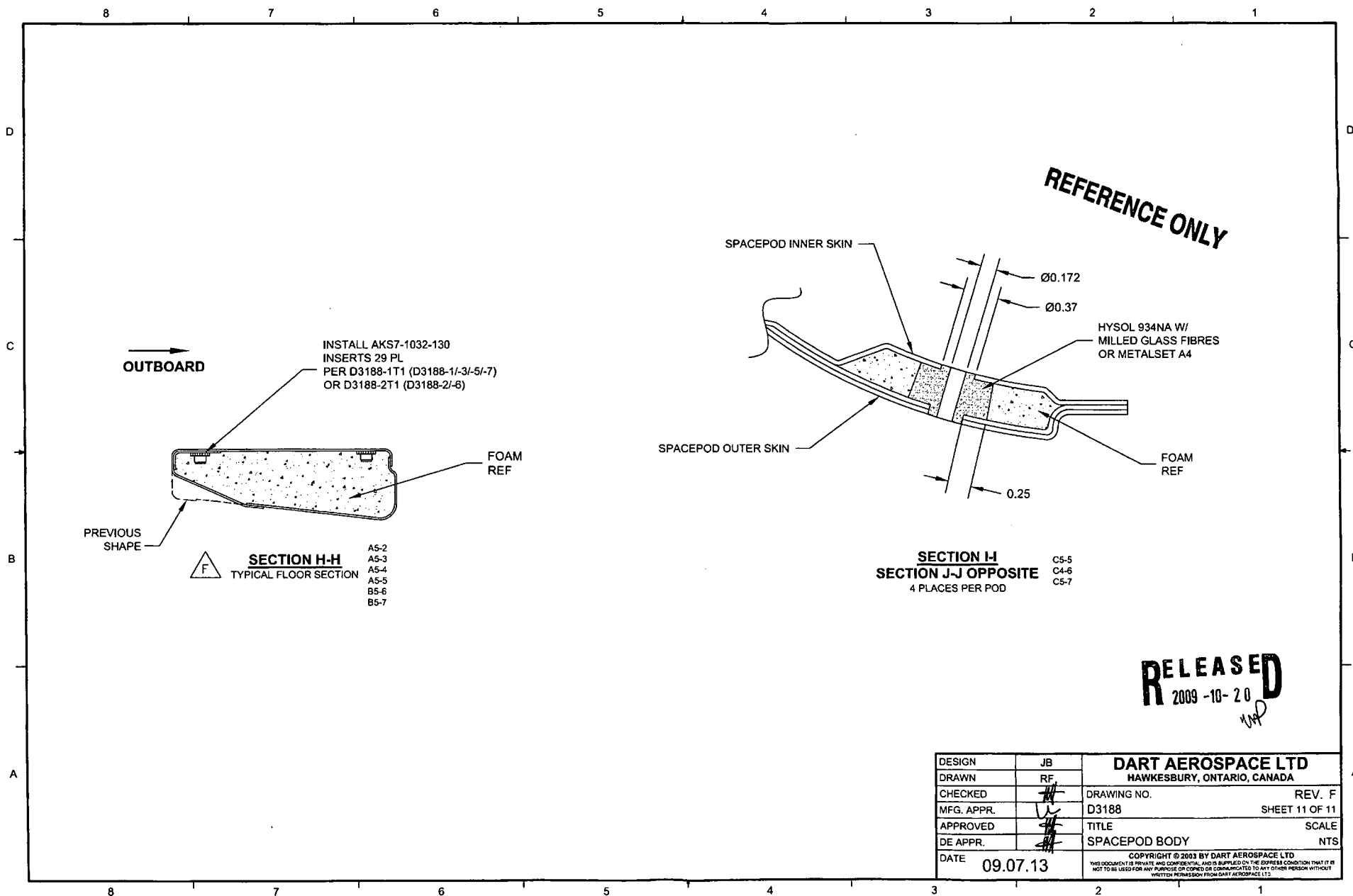


SECTION E-E
2 PLACES PER POD
C2-8
C7-8
B6-9

RELEASED
2009-10-27
ND

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	JB	D3188	SHEET 10 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	SPACEPOD BODY	NTS
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8 7 6 5 4 3 2 1





Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33697
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Point de départ		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
29/06/2010	20/05/2010	14195	Chantal Lavoie	PO11949			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0058	Line #5 D31861P Spacepod Door LH B58917 Dwg. Rév.: E <u>No. série</u> B58917 <u>No. lot</u> 26648 U de M : Eac			
1	0	1	DKC134-0070	Line #6 D31881P, Spacepod Body LH B58914 Dwg. Rév.: F <u>No. série</u> B58914 <u>No. lot</u> 26653 U de M : Eac			
5 10/09/13							

5/10/09/13

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

[Signature]

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Date: Vendredi, 2010-05-21 10:30:44
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 26653
Numéro Soumission : 3766
Numéro B.A. :
Cette fois : 2010-05-21 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 26652Nom Dessin : SPACEPOD BODY LH
Numéro Article : DKC134-0070
Numéro Dessin : ~~D3188~~
Projet Numéro : DK-362
Révision dessin : F
Matériel : Fibre 7781 et résine 411-350
Date Dûe : 2010-05-28 Qté: 1 Udm: UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D3188-1Inscrire le N° de
Série : B58914 Sur la
pièce

Process Sheet Rév.: 01 ajout des numéros d'IF/IG

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.05 UNITE(s)/Unit Total : 0.05 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0019.

Date: 2-6-10 Heure Début: _____ Heure Fin: _____ Sceau:

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)

4.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26697-1

8.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

Date: Vendredi, 2010-05-21 10:30:44
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26653

Nom Dessin: SPACEPOD BODY LH
Numéro Article: DKC134-0070

Numéro Job:



Séq.: Machine ou Opération: Description :

9.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentaire Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-22302-1

10.0 AC0886 Ruban à gommer jaune #: T/T-200Y

Commentaire Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0019.

Date: 21/05/10 Heure Début: — Heure Fin: — Sceau:

12.0 AMB0286 Catalyst N° DDM-9

Commentaire Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27457-1

14.0 AAC1540 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-7076-1

15.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0019.

Date: 21/05/10 Heure Début: — Heure Fin: — Sceau:

16.0 AMB0355 ATC core-cell A500 plain 4'x8' 1" thick

Commentaire Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-6173-2

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.200 LITRE(s)/Unit Total : 0.200 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27457-1

18.0 AMB0286 Catalyst N° DDM-9

Commentaire Qty.: 0.0064 GALLON(s)/Unit Total : 0.0064 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

Date: Vendredi, 2010-05-21 10:30:44
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD
Numéro Job: 26653

Nom Dessin: SPACEPOD BODY LH
Numéro Article: DKC134-0070

Numéro Job:



Séq.: Machine ou Opération: Description:

19.0 AAC1611 Polybond B46F


Commentair Qty.: 0.010 KIT(s)/Unit Total: 0.010 KIT(s)
Polybond B46F N° de Lot: 1-7089-1

20.0 TAILLAGE Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run: 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0019.

Date: 7-6-10 Heure Début: — Heure Fin: — Sceau:  

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total: 0.300 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27457-1

22.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total: 0.0096 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

23.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs

Sceller les foam core selon IF134-0019.


Date: 7-6-10 Sceau:   Initiales: C.G.S.V.

24.0 PERCAGE Perçage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Percer les foam core selon IF134-0019.

Date: 7-6-10 Sceau:  Initiales: C.G.

25.0 AAC1611 Polybond B46F




Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 1-26580-1

26.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Installer les foam core selon IF134-0019.

Date: 8-6-10 Heure Début: — Heure Fin: — Sceau:   

Date: Vendredi, 2010-05-21 10:30:45
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 26653

Nom Dessin: SPACEPOD BODY LH
Numéro Article: DKC134-0070

Numéro Job:



Séq.: Machine ou Opération: Description:

27.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.100 KIT(s)/Unit Total: 0.100 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-7129-1

28.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total: 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot: _____

29.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Usiner les foam core selon IF134-0019.

Date: 8-6-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



30.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total: 1.600 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-27663-1

31.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total: 0.0536 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

32.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs

Laminer les plis de 9oz selon IF134-0019.

Date: 18-6-10

Heure Début: _____

Heure Fin: _____

Sceau: _____



A.M.

33.0 TRIMAGE Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Faire le taillage selon IF134-0021.

Date: 2/10/10

Heure Début: _____

Heure Fin: _____

Sceau: _____



34.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total: 0.0144 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

Date: Vendredi, 2010-05-21 10:30:45
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD
Numéro Job: 26653

Nom Dessin: SPACEPOD BODY LH
Numéro Article: DKC134-0070

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-7076-1

36.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27663

37.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage après taillage selon IF134-0019.

Date: 22/06/10 Heure Début: — Heure Fin: — Sceau:



38.0 AAC1610 Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Spacer N° D2213 N° de Lot: 1-27599-2

39.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG0097.

Date: 23/06/10 Heure Début: — Heure Fin: — Sceau:



40.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-26575-4

41.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-26804-2

42.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG0008.

Quantité: 1 Date: 28/06/10 Sceau:



Date: Vendredi, 2010-05-21 10:30:45
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Jcb: 26653

Nom Dessin: SPACEPOD BODY LH
Numéro Article: DKC134-0070

Numéro Job:




Séq.: Machine ou Opération: Description :

43.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008 et la fiche technique.

Qté: 1 Date: 29/06/10 Sceau:  # de fiche de mélange: N/A

1x Primer final
29/06/10



44.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.020 KIT(s)/Unit Total : 0.020 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-7129-1

45.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens


N° de Lot:

46.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG0008.

Date: 29-6-10 Heure Début: Heure Fin: Sceau: 

47.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.


Date: 29-6-10 Sceau:  Initiales: MS

48.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage dans le contenant approprié.

Quantité: 1 Date: 29-06-10 Sceau: 

**Inscrire le N° de
Série : B58914 Sur la
pièce**